

order 11228



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Canada

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RB T101530-7
Job Sheet 188955



Part No: RB T101530-7

Job Qty: 6 ea

Part Name: Bearing Roll Stake Body



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/17/19

Job Tracking No:

Due Date: 2/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB T101530 Rev.A IPP Rev. A 18.05.30 new issue DP Verify DD/IPP Rev. B 18.07.04 new DWG. DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		2/8/19	0.00	0.00	Start Up Machining-3		<i>M/L</i> 1/10/25
110	CNC Lathe	6 pcs		2/8/19	0.00	6.00	SL-154		<i>M/L</i> 1/10/25
120	QC	6 pcs		2/8/19	0.00	0.00	QC2 Machining-4		<i>M/L</i> 1/10/25
130	QC	6 pcs		2/8/19	0.00	0.00	QC8 Machining-4		<i>M/L</i> 1/10/25
140	Packaging	6 pcs		2/8/19	0.00	0.00	Packaging3-1		<i>M/L</i> 1/10/25
150	QC21-SA	6 Ea		2/8/19	0.00	0.00	QC21		<i>M/L</i> 1/10/25

Part Op 110 - 1-Machine as per DWG. FC200 FOLIO REV: 4A DWG REV: A 2-Debur
Descriptions: 130 - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG.

FEB 07 2019

21
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-R1.000	17-4 SS H900 Round Bar 1.00"	1.6500 ft (.275 ea)	90-Start up Operation	<u>5041668</u>

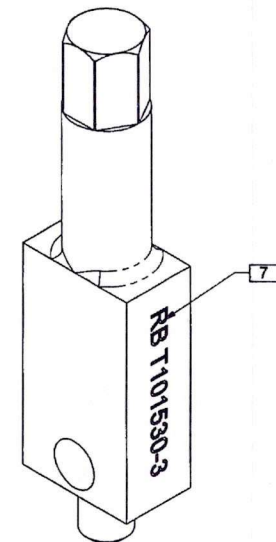
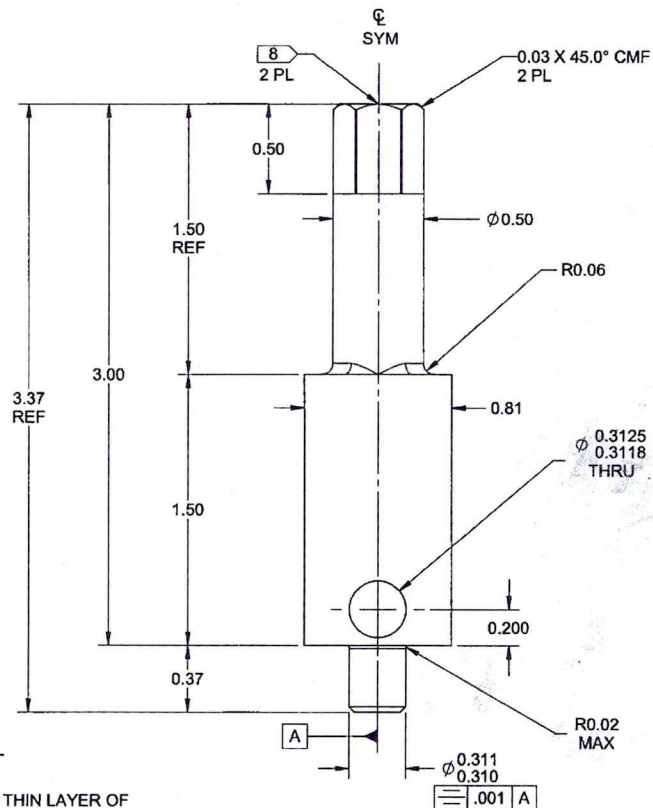
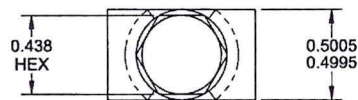
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H900-R1.000	2	17	0

Part Specifications

Specifications could not be found.

Plex 1/17/19 7:56 AM Dart.lajeunesse.marie



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 188955 MLS
19-01-17

- NOTES:
1) MATERIAL: 4140/4142 (28-32 RC) OR 17-4 PH-H900-H1150 STAINLESS STEEL
2) HEAT TREAT: N/A
3) FINISH: 17-4PH: N/A
4140/4142: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: MACHINE ENGRAVE PER CAD MODEL OR DOT MARK T/N AS SHOWN.
8) CENTER DRILL IS ACCEPTABLE

RB T101530-7 BODY

DESIGN	KK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KK		
CHECKED	<i>ML</i>	TOOL PART #	REV. A
MFG. APPR.	DP	RB T101530	SHEET 4 OF 10
APPROVED	<i>ML</i>	TITLE	SCALE
DATE 7/4/2018		BEARING ROLLER TOOL (-3/-5)	NTS
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S147811



Part: RB T101530-7

Job No: 188955

Serial No/Batch: S147811

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 01/25/19